

Work Order ID 70148-25918

Monday, May 30, 2011 11:23:39 AM



Page 1

Item ID: D3197-041

Accept



Setup

Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 11-05-2011

Date:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3197	Rev B
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100	BAND SAW
-----	----------

	Memo
--	------

Bandsaw	Cut blanks 29 125" long
---------	-------------------------

110	HAAS CNC VERTICAL MACHINING #1
-----	--------------------------------

	Memo
--	------

HAAS 1	I-Face ends to length per dwg D3197-2-Machine D3197-1 as per Folio FA340 and Dwg D3197-3-Deburr
--------	--

120	QC2- Inspect parts off machine FA1/FA2
-----	--

	Memo
--	------

Quality Control
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**Work Order ID 70148**

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Item ID: D3197-041

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Setup Start



Revision ID:

Item Name: Bar Assembly

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Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Lathe Conv

Conventional Lathe

Operation  
Description

CONVENTIONAL LATHE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

21 11/06/02

6 10

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

21 11/06/02

6 10

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

0.00

6 10 21 11/06/02

**Work Order ID 70148**

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Setup

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Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Powdercoat

Powder Coating

M115128

Memo

START TIME

9:30

0.00

OVEN TEMPERATURE

10:00

170



QC

Quality Control

QC3-Inspect Part Finish

0.00

Ex/8 Mf/nb6b2

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble D3197-041 as per Dwg D3197

6 4 FLU-62

Edu/06/08 Q

# Work Order ID 70148

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Item ID: D3197-041

Accept



Setup



Start



Revision ID:

Item Name: Bar Assembly

Stop



Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run



Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

199

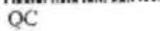
QC5- inspect part completeness to step on W/O

0.00

*Subtotal*

0.00

*+40*



QC

Memo

200

Identify as per dwg & Stock Location *260*

0.00

*16/8 420*



Packaging

Memo

0.00

210

QC21- Final Inspection - Work Order Release

0.00

*11/6/08*



QC

Memo

0.00

*MF  
11-06-08*

# Picklist Print

Monday, May 30, 2011 11:23:36 AM

Page 1

Work Order ID: 70148



Parent Item: D3197-041



Parent Item Name: Bar Assembly

Start Date: 5/30/2011

Required Date: 6/10/2011

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev:B As per Rev B 06-03-10 JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10



NAS1149D0463J

Purchased

4D9116583 (240)

Washer

D2690-5



Lanyard Assembly

D3242-1



Tag

D3489-3-200



PIP PIN

Location

Loc Qty

Loc Code

ST020

11

66820

11

Manufactured

No

180

Each

4 0000



EP11/06/06

EP11/06/06

B70390 (1x)

ST044

4

65390

4

Manufactured

No

180

Each

9.0000



EP11/06/06

B70154 (8d)

GA

9

68563

9



5

V

V

V

V

# Picklist Print

Page 2

Monday, May 30, 2011 11:23:36 AM

Work Order ID: 70148

Parent Item: D3197-041

Parent Item Name: Bar Assembly



Start Date: 5/30/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

M7075-T73R1.000

Purchased

No

180

F

30.8650

2.42

12.1



SL 11/06/02

7075-T73 Rd Bar 1.00

Location	Loc Qty	Loc Code
MAT012	30.865	
115165	2.7	
116405	4.54	
116604	2.25	
116835	12	7.68
116962	9.375	4.81

MS21042L3

Purchased

No

180

Each

2.119.000

2



Nut

Location	Loc Qty	Loc Code
ST300	2119	
116391	11	
116540	142	
116549	766	
117441	800	8
117601	400	

MS27039-1-24

Purchased

No

100

Each

122.0000

2



Screw

Location	Loc Qty	Loc Code
ST292	122	
100151	122	8

DART AEROSPACE LTD	Work Order:	70-148
Description: Bar	Part Number:	D3197-1
Inspection Dwg: D3197	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

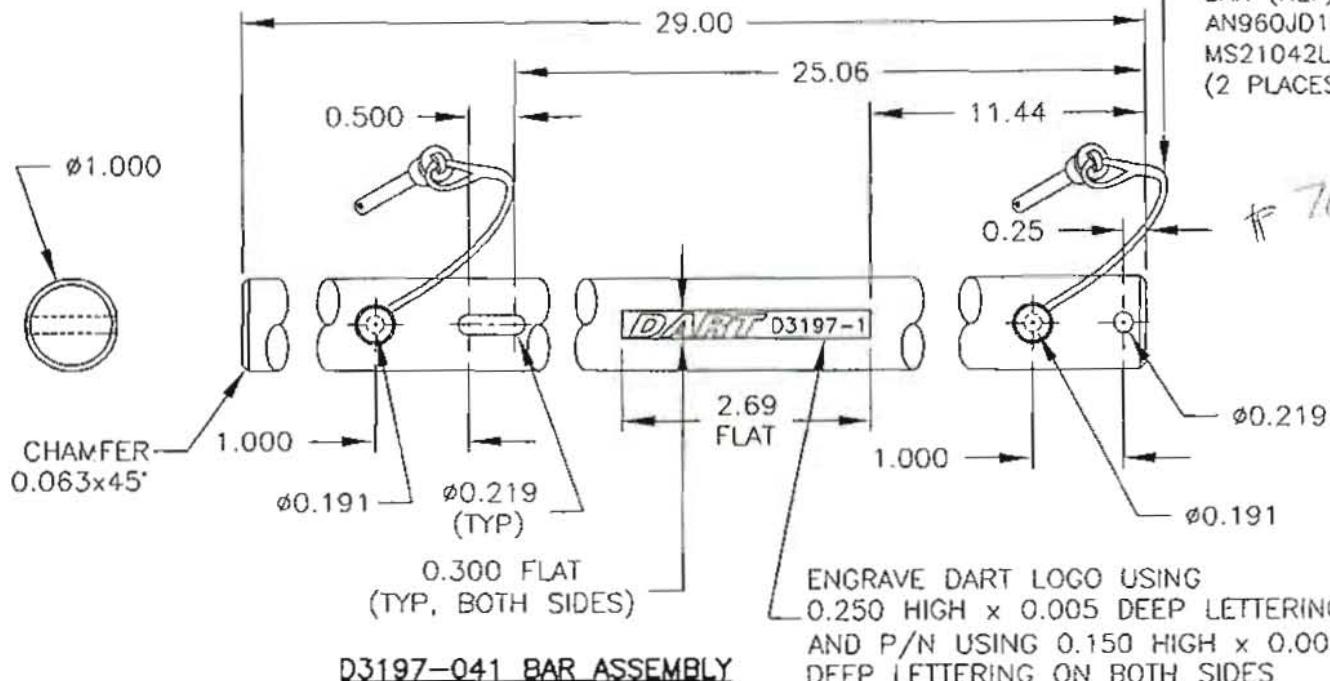
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	/		IN-TOPE	
25.06	+/-0.030	25.36	/			
11.44	+/-0.030	11.436	/		VERNUC-42	
0.500	+/-0.010	499	/		VERNUC-3	
0.250	+/-0.030	245	/		"	
Ø0.219	+0.005/-0.000	.219	/		"	
Ø0.191	+0.005/-0.000	.192	/		"	
1.000	+/-0.005	1.000	/			
2.69	+/-0.030	2.689	/		"	
1.002	+/-0.010	1.000	/		"	
0.300	+/-0.010	305	/		"	
0.063 x 45°	+/-0.010	06x45	/		"	
Ø1.000	+/-0.010	.998	/		"	

Measured by:	jin	Audited by:	Tom	Prototype Approval:	N/A
Date:	11/06/02	Date:	11/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	EE

RELEASED  
02-03-04  
C.N. 70148

**DART**



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DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3197
DATE	06.01.10	TITLE BAR
A	03.07.01	REV. B SHEET 1 OF 1
B	06.01.10	SCALE 1:1
		CHG PIP PIN; ADD 03242-1 TAG

**D3197-1 BAR**

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) Ø1.000 O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER  
END OF THE BAR